Dart Aerospace Ltd. Wednesday, 12/13/2006 2:48:01 PM Date: Kim Johnston 🛩 User: **Process Sheet** : FUEL PURGE CANISTER **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 29937A **Estimate Number** : 10441 Part Number : D32621 : NIA P.O. Number : D3262 REV C **Drawing Number** : 12/13/2006 This Issue : N/A Project Number Prsht Rev. : MACHINED PARTS Type **Drawing Revision** First Issue : UM : 28240 Material **Previous Run** : 1/10/2007 6 Um: Each **Due Date** Qty: Written By Checked & Approved By Removed P/O for liquid penetrant inspection K Comment J/JLM **Additional Product** Job Number: Seq. #: **Machine Or Operation:** Description: 6061-T6 Tube 5.00X.125W 1.0 M6061T6T5000W125 0.9406 f(s)/Unit Total: 5.6435 f(s) Comment: Qty.: Material: 6061-T6 (QQ-A-200/8 or 225/8) 5.00 OD x 0.125" wall (M6061T6T5.000W.125) Identify as D3262-1 ant 07/01/07 Batch: M102019 BAND SAW BAND SAW 2.0 Comment: BAND SAW Cut D3262-1 to length as per Dwg D3262 Identify as D3262-1 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 3.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr 4.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK QC8 5.0

Comment: SECOND CHECK

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W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
												
	<u> </u>											

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date: 07/01/0
			QA: N/C	Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspecto				
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NOTE: Date & initial all entries

Date:

Wednesday, 12/13/2006 2:48:01 PM

Kim Johnston User:

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 29937A

Part Number: D32621

Job Number:



Seq. #:

Machine Or Operation:

Description:

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock Location: 51 10



7.0

QC21

Comment: FINAL INSPECTION/W/O RELEASE



B87101108

Job Completion



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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector				
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Part No	:	PAR #: Fault Category:	NCR: Ye	s No DQ	A:	Date: _					
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	WORK ORDER NON-CONFORMANCE (NCR)									
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STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspecto			

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 2993	<u> </u>
Description: Tube	Part Number: D3262-	1
Inspection Dwg: D3262 Rev: Ø C 766.	2.17 Page 1 or	f 1

Inspection Dwg	: D3262 Rev	A CONTRACTOR OF THE PROPERTY O	196.12.17	<u>'</u>			gerori
	FIRS	TARTICLE IN	NSPECTI	ON CHE	ECKLIST		
	X	First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
10.50	+/-0.030	10,520					
			-			-	 ;
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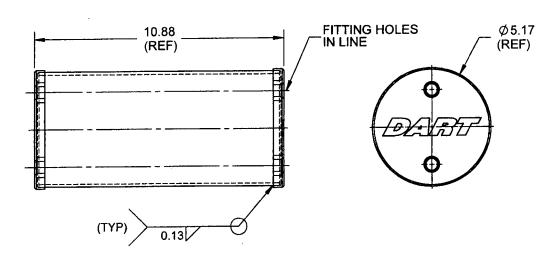
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Measured by:	me	Audited by:	TI		Prototype A	pproval:	N/A
Date:	02/01/07	Date:	07/0/	1/07		Date:	N/A
Rev Date	Change				F	Revised by	Approved

Rev	Date	Change	Revised by	Approve⁄d
Α	06.05.24	New Issue	KJ/JLM 🚓	411
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	CHECK	(ED	APPRO	ĶED	DRAWING NO.	REV. C		
	6	PH H		-	D3262	SHEET 1 OF 2		
	DATE				TITLE	SCALE		
1	06.08.31				FUEL PURGE CANISTER	1:4		
_	REV		DATE		DESCRIPTION			
	Α	0.4.05.00			FIRST ISSUE			
	B 05.02.14			ADD PRESSURE TESTING OPTION				
	С	(06.08.31		Ø5.165 WAS Ø5.190			

HELEASED 06.04.19



D3262-041 CANISTER ASSEMBLY

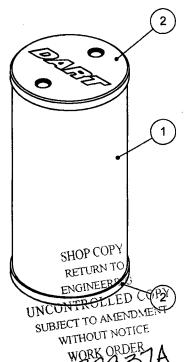
ITEM	QTY -041	P/N	DESCRIPTION
	X	D3362-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

NOTES:
1) WELD PER DART QSI 004

2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER

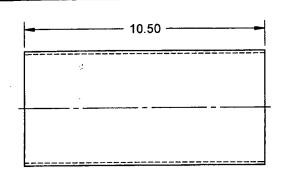


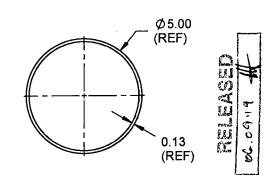
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DESIGN	DRAWN BY	DART AEROSPACE I HAWKESBURY, ONTARIO, CANA	
CHECKED PH	APPROVED	DRAWING NO. D3262	REV. C SHEET 2 OF 2
DATE 06.	08.31	TITLE FUEL PURGE CANISTER	SCALE 1:4





DRILL THRU Ø0.516

D3262-1 TUBE

1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR

QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T5.000W.125)

(33/64 DRILL), TAP HOLE Ø 5.165 (REF) - 0.45 9/16-18 UNF-3B $\phi_{0.688}^{+0.015}_{-0.000}$ PER MIL-S-8879 (2 PLACES) (2 PLACES) Ø0.875 (2 PLACES) 1.63 Ø5.005^{+0.010} -0.000 3.25 (REF) R0.063 ϕ 0.580 $^{+0.005}_{-0.000}$ (TYP) (2 PLACES) RETUR $0.083^{+0.015}_{-0.000}$ ENGINEARIN UNCONTROLLED COPY 0.080 0.070 x 45° 0.33 (TYP) CHAMFER SUBJECT TO AMENDMENT (TYP) WITHOUT NOTICE 30 SECTION A-A SCALE 1:2 WORK ORDER D3262-3 CAP $R0.02^{+0.02}_{-0.00}$ 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B) R0.02^{+0.00}_{-0.01}

- NOTES: 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE 7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)

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